

Date: Monday, 07/07/2008 8:35:18 AM
 User: Julie Lecocq

Process Sheet

Customer	CC-DAR01	Dart Aerospace Ltd.	Drawing Name	FRONT INBOARD LEG ASSEMBLY
Job Number	40303			
Estimate Number	13320			
P.O. Number	:		Part Number	D3782041
This Issue	07/07/2008	S.O. No. :	Drawing Number	D3782 REVA
Prsh Rev.	NC		Project Number	N/A
First Issue	/ /	Type : SMALL /MED FAB	Drawing Revision	A
Previous Run	05014		Material	:
Written By	:		Due Date	30/07/2008
Checked & Approved By	Jul 08.7.07			
Comment	Est Rev:A 08-05-19 new issue DD verified by:ec Est Rev:B 08-06-17 rev.A as per dwg DD verified by:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1		
	Pick Packing Kit		
2.0	D37681	Front Inboard Leg	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Front Inboard Leg		
	batch: B40312		
3.0	D37871	Foot	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Foot		
	batch: 39397		
4.0	AN513A	Bolt	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Bolt		
	batch: M168167		
5.0	AN960JD516	Washer	
	Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)		
	Washer		
	batch: M167959		
	or (NAS1149D0568J)batch:		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 8:35:18 AM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: FRONT INBOARD LEG ASSEMBLY

Job Number: 40303

Part Number: D3782041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M107939

AS 08/08/01 (X)

7.0 AN45 13A

EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

eye Bolt

batch: M107938

AS 08/08/01 (X)

8.0 D3762041

Front Leg Fitting Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Front Leg Fitting

B# 40303

SAP 08/08/11

(2)

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3782

****install AN45-13A eye bolt as shown for D412-769-041****

****install AN45-13A eye bolt in reverse for D412-769-042****

SAP 08/08/11 (2)

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 135

AS 08/08/11 (X)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/11

MF 08-08-11

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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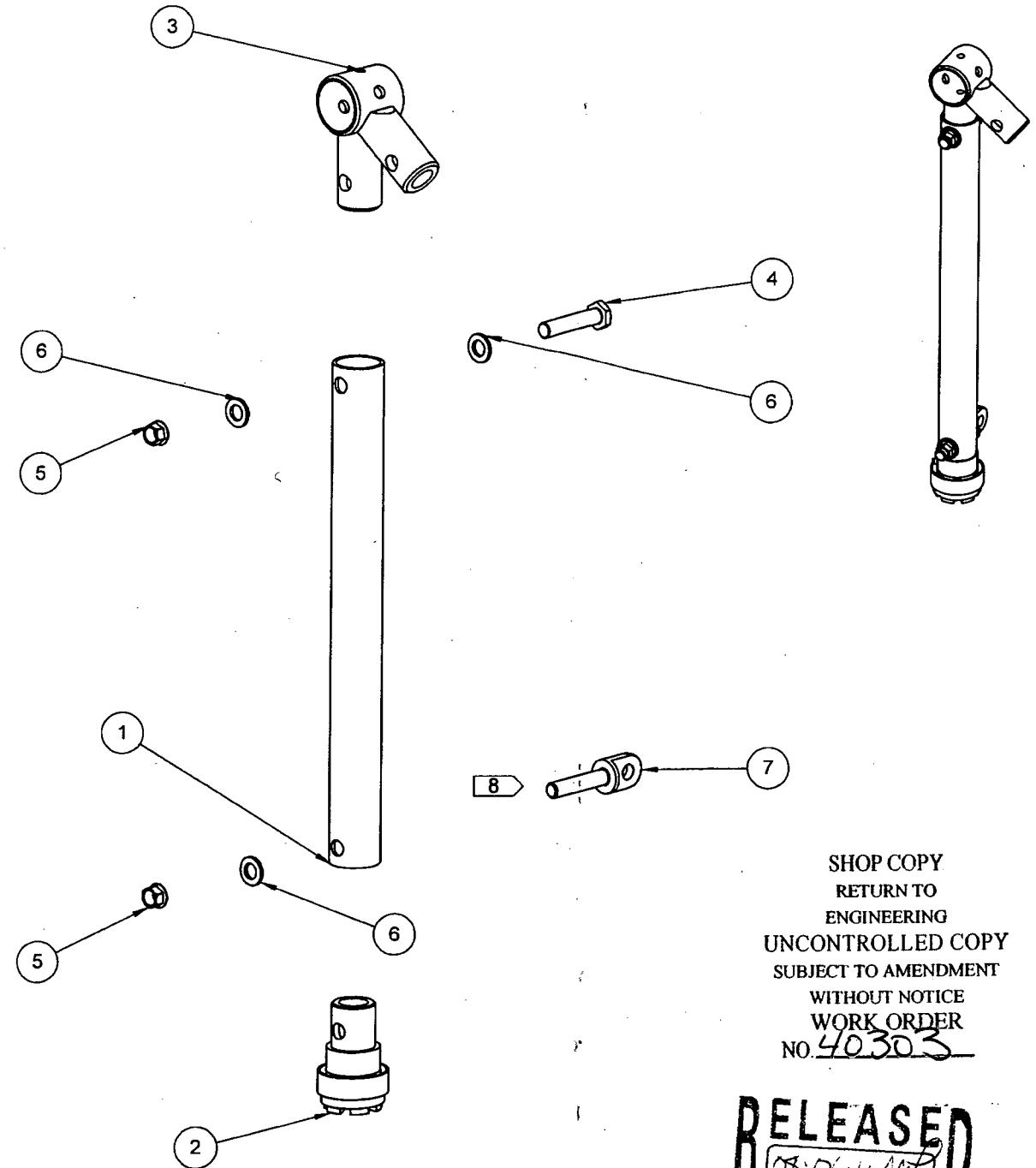
D

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3768-1	FRONT INBOARD LEG	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN5-13A	BOLT	1
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	3
7	AN45-13A	EYE BOLT	1

C

B

A



D3782-041 FRONT INBOARD LEG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) ITEM 6 (AN45-13A EYE BOLT) INSTALLED AS SHOWN FOR D412-769-041 AFT FACING SEAT, LH
INSTALLED IN REVERSE FOR D412-769-042 AFT FACING SEAT, RH

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	24	DRAWING NO.	REV. A
MFG. APPR.		D3782	SHEET 1 OF 4
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08.06.04

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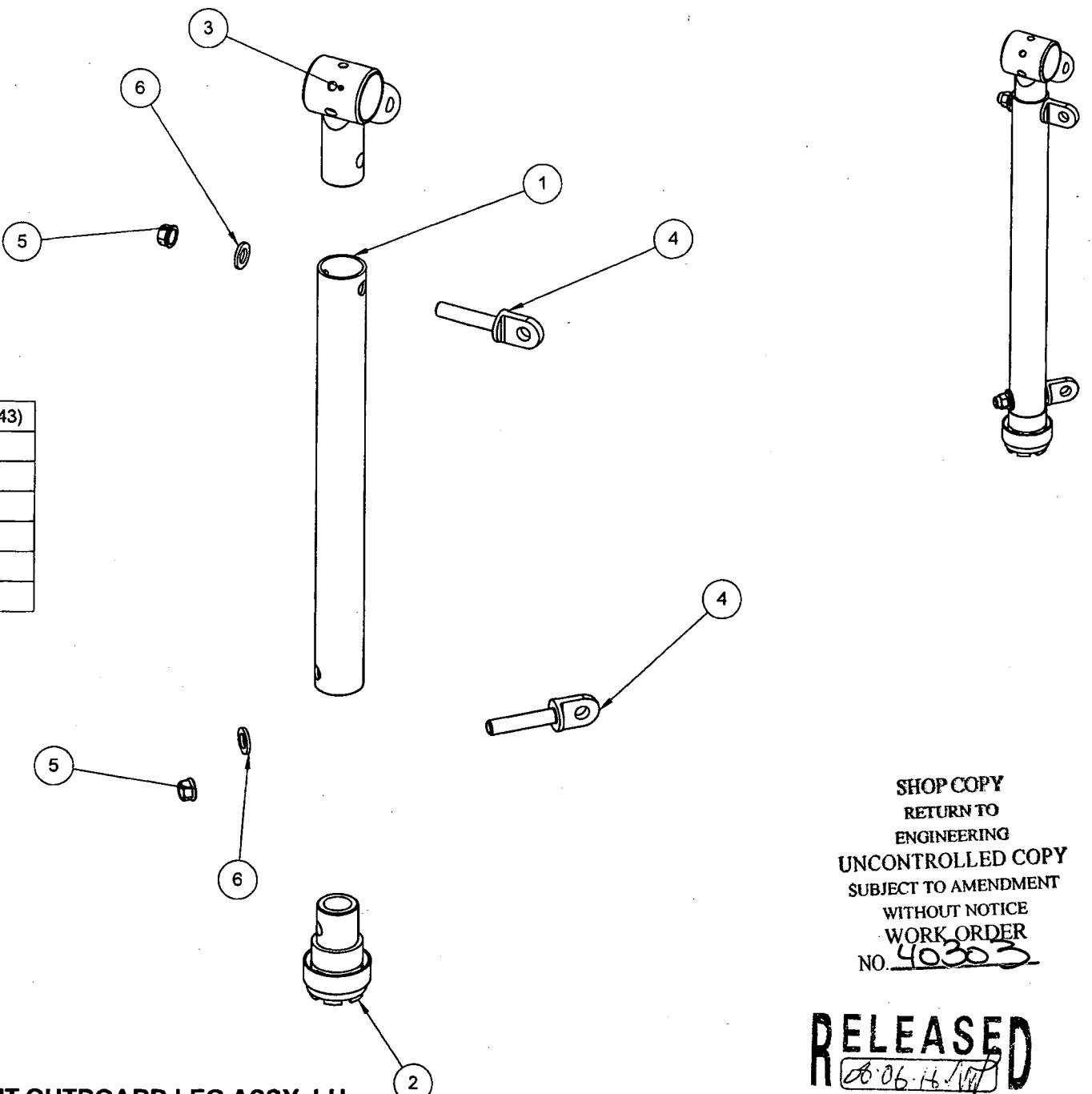
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3768-3	FRONT OUTBOARD LEG, LH	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN45-13A	EYE BOLT	2
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	2



D3782-043 FRONT OUTBOARD LEG ASSY, LH

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.42 lbs

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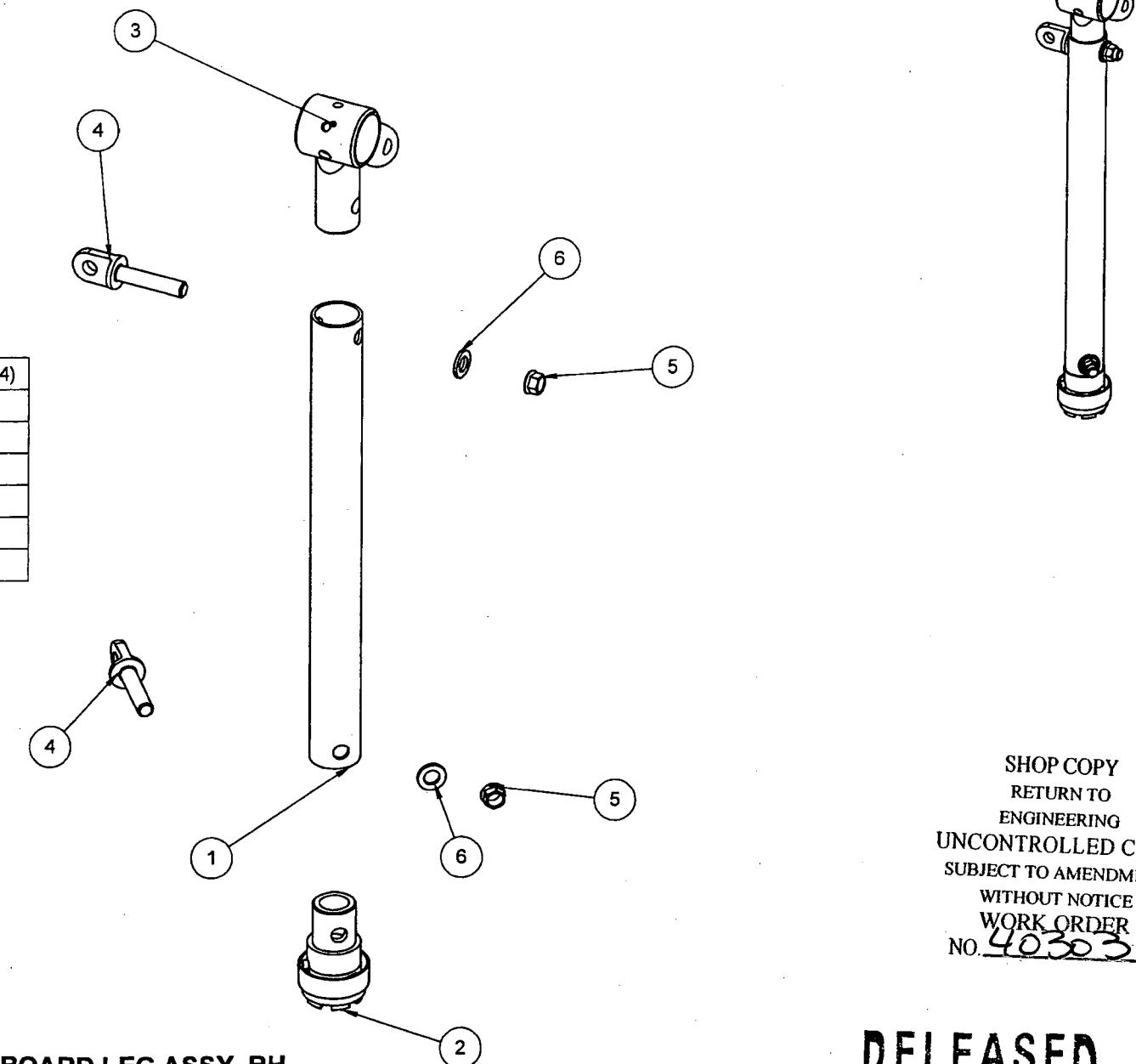
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3768-4	FRONT OUTBOARD LEG, RH	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN45-13A	EYE BOLT	2
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	2

D3782-044 FRONT OUTBOARD LEG ASSY, RH



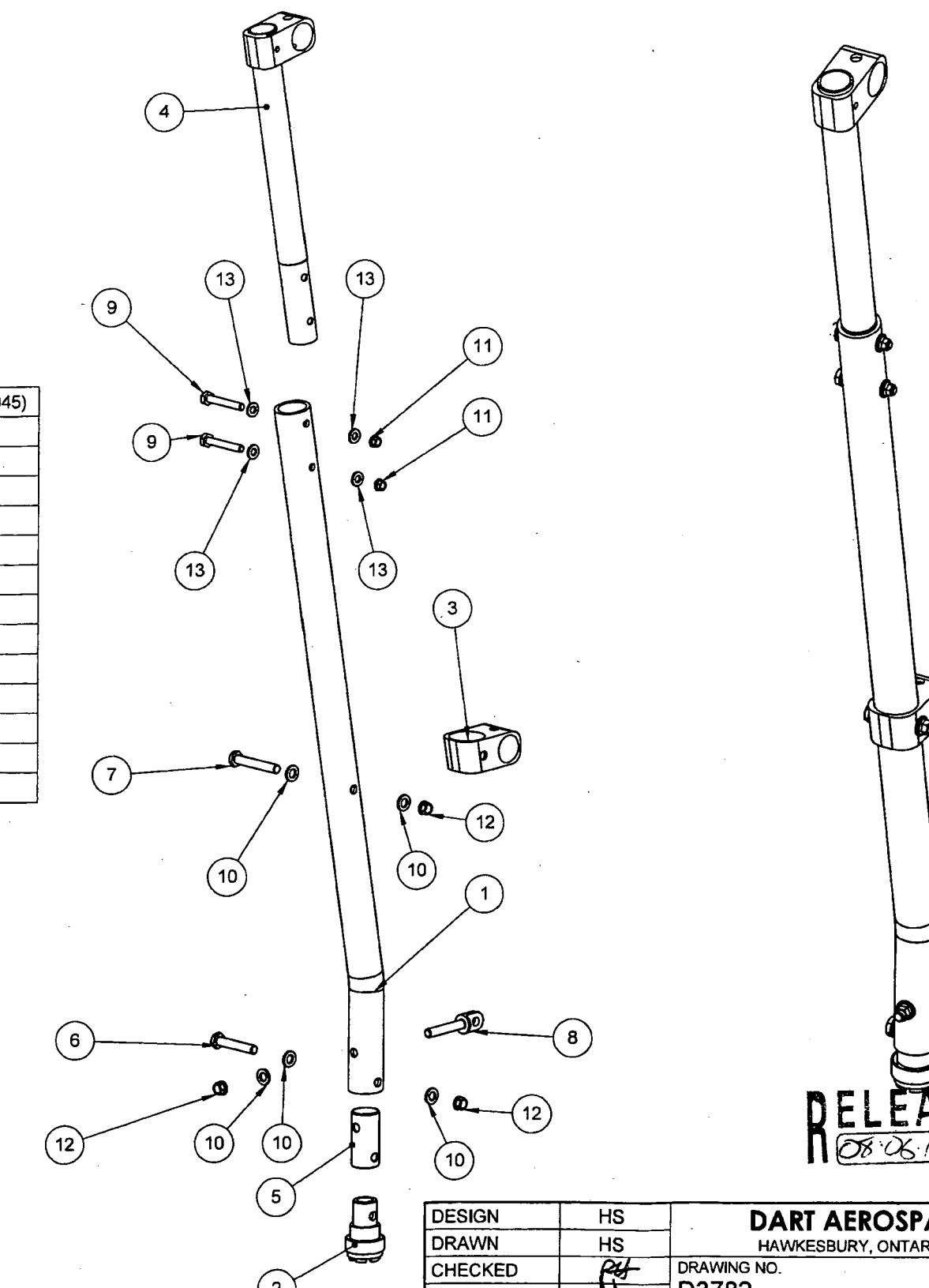
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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

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D3782-045 BACK LEG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.71 lbs

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